

Date: Tuesday, 10/02/2009 3:09:54 PM
 User: Julie Dawson

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	WEB ASSEMBLY
Job Number :	45729		
Estimate Number :	13599		
P.O. Number :		Part Number :	D3815041
This Issue :	10/02/2009	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D3815 REV A
First Issue :	/ /	Project Number :	N/A
Previous Run :		Drawing Revision :	A
Written By :		Material :	
Checked & Approved By :	JLD 09.02.10	Due Date :	28/02/2009
Comment :	Est Rev:A 08-09-18 new issue DD verified by:EC		

Qty: 21
 12 Um: Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1
 Pick Packing Kit

2.0	D38151	Angle
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 12.0000 Each(s)
 Angle
 batch: B45832

Ep09/03/05

3.0	D38152	Angle
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 12.0000 Each(s)
 Angle
 batch: B45834

Ep09/03/05

4.0	D38153	Web
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 12.0000 Each(s)
 Web
 batch: B45835

Ep09/03/05

5.0	MS20470AD46 MS20470AD5-6	Rivet, Universal Head
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Comment: Qty.: 25.0000 Each(s)/Unit Total : 300.0000 Each(s)
 Rivet, Universal Head
 batch: M9619

Ep09/03/05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 10/02/2009 3:09:54 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEB ASSEMBLY

Job Number: 45729

Part Number: D3815041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

AN526C832R14

Screw



* Comment: Qty.: 4.0000 Each(s)/Unit Total: 48.0000 Each(s)

Screw

batch: M 9216 (79)

M 104916 (5)

EP 09/03/05

7.0

MS21042L08

Nut



* Comment: Qty.: 4.0000 Each(s)/Unit Total: 48.0000 Each(s)

Nut

batch: M 109174 65

M 110002 19

EP 09/03/05

8.0

NAS1149DN832J

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total: 48.0000 Each(s)

Washer

batch: M 110844

EP 09/03/05

9.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- install rivets as per dwg D3815

EP 09/03/05 (21)

PTD

counter

(21)

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

EP 09/03/05 (21)

11.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M 110939

(21)

START TIME:

8:30

OVEN TEMPERATURE:

320°

FINISH TIME:

9:00

16L 09-03-06

12.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

09-03-09

(21)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			


NOTE: Date & initial all entries

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3815-041 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR: <u>45729</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
09-03-04	9.0	Upon Assembly it was noticed all the rivets were being pressed crooked. After investigating the matter, it was noticed that the 0.128" rivet holes were at max tolerance, and with the additional taper in the hole, slightly oversize, and causing the rivets to be slightly loose.	 MS142	Removed rivet already on. MS20470AUS-6 redrill holes at .156 and Took rivet MS20470AUS-6	EB 09/03/05	EB 09-03-04	EB 09-03-04	EB 09-03-04
		RC: Max tolerance on W.S.						

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEB ASSEMBLY

Job Number: 45729

Part Number: D3815041

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- install screws loose (4 places) as per dwg D3815

EP 09/03/10

(21)

14.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB 09/03/10

(21)

15.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with Dart part # using a fine point permanent marker and Stock

Location: _____

9/3/10

(214)

56

16.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/03/10

Job Completion



WRF
09-03-10

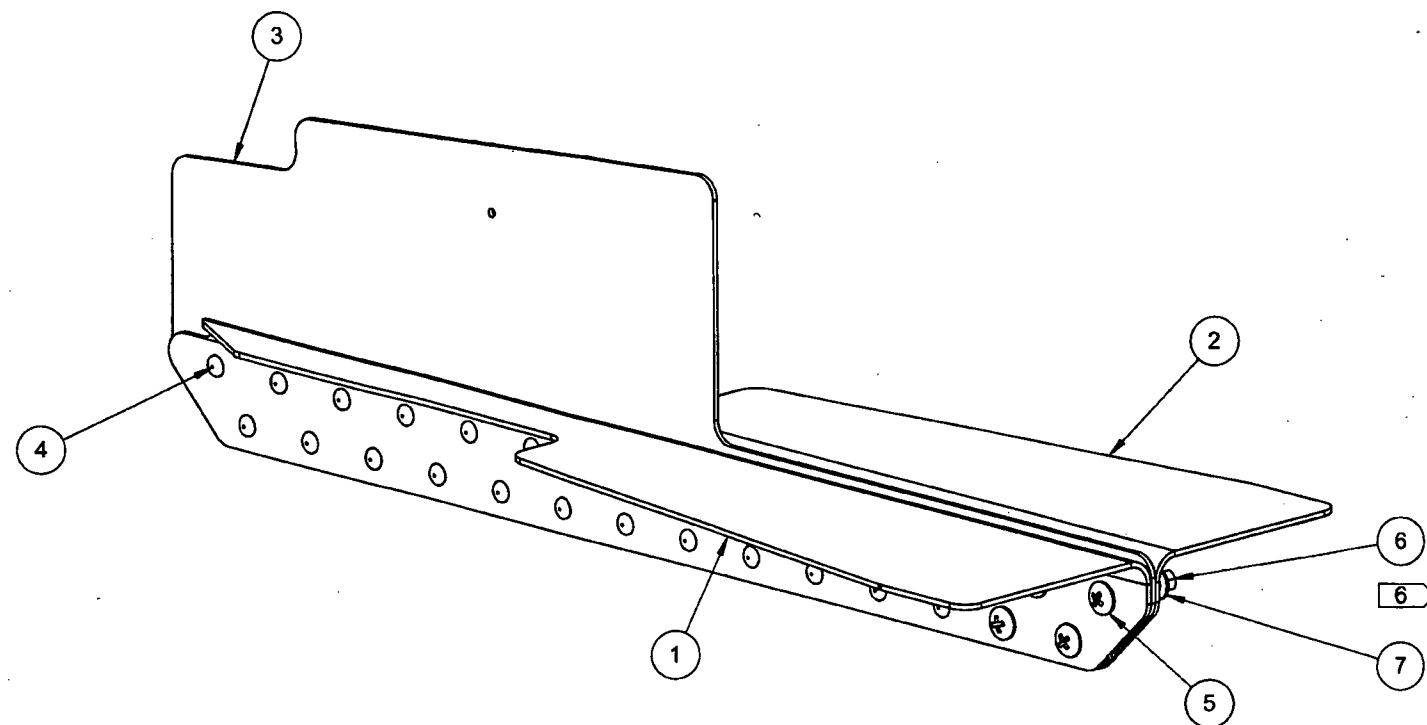
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



ITEM NO.	PART NUMBER	DESCRIPTION	QTY. .041
1	D3815-1	ANGLE	1
2	D3815-2	ANGLE	1
3	D3815-3	WEB	1
4	MS20470AD4-6	RIVET	25
5	AN526C832R14	SCREW	4
6	MS21042L08	NUT	4
7	NAS1149DN832J	WASHER	4

D3815-041 WEB ASSEMBLY

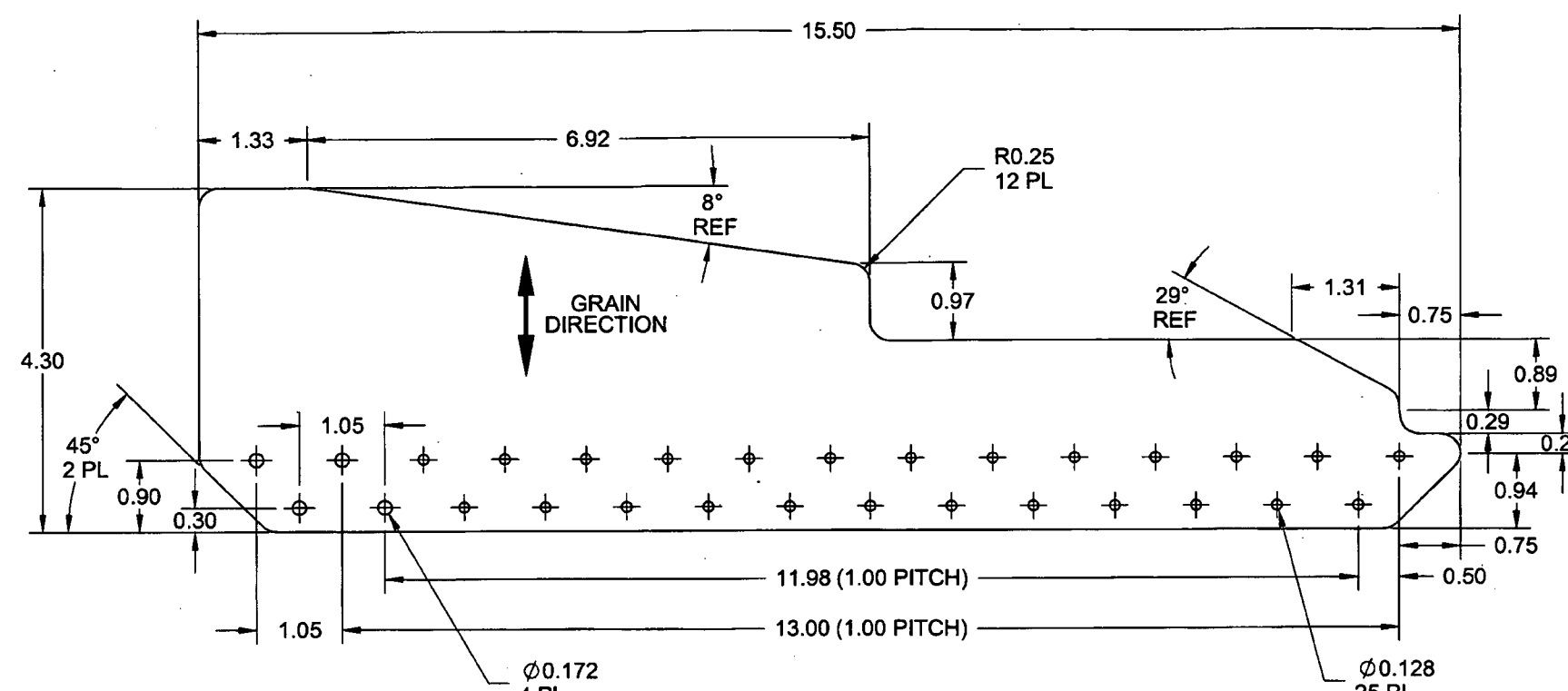
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WORK ORDER
NO 45729

NOTES:

- 1) FINISH: POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 2) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) UNITS: INCHES UNLESS OTHERWISE NOTED
- 4) IDENTIFICATION: IDENTIFY WITH DART P/N D3815-041 USING FINE POINT PERMANENT INK MARKER
- 5) WEIGHT: 0.88 lbs
- 6) INSTALL LOOSE (4 PLACES) AFTER POWDER COAT

A	NEW ISSUE	08.09.22
REV.	DESCRIPTION	BY DATE
DESIGN	 DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	REV. A
DRAWN		
CHECKED		
MFG. APPR.		
APPROVED		
DE APPR.		
DATE	08.09.22	
DRAWING NO. D3815 SHEET 1 OF 5 TITLE WEB SCALE NTS		
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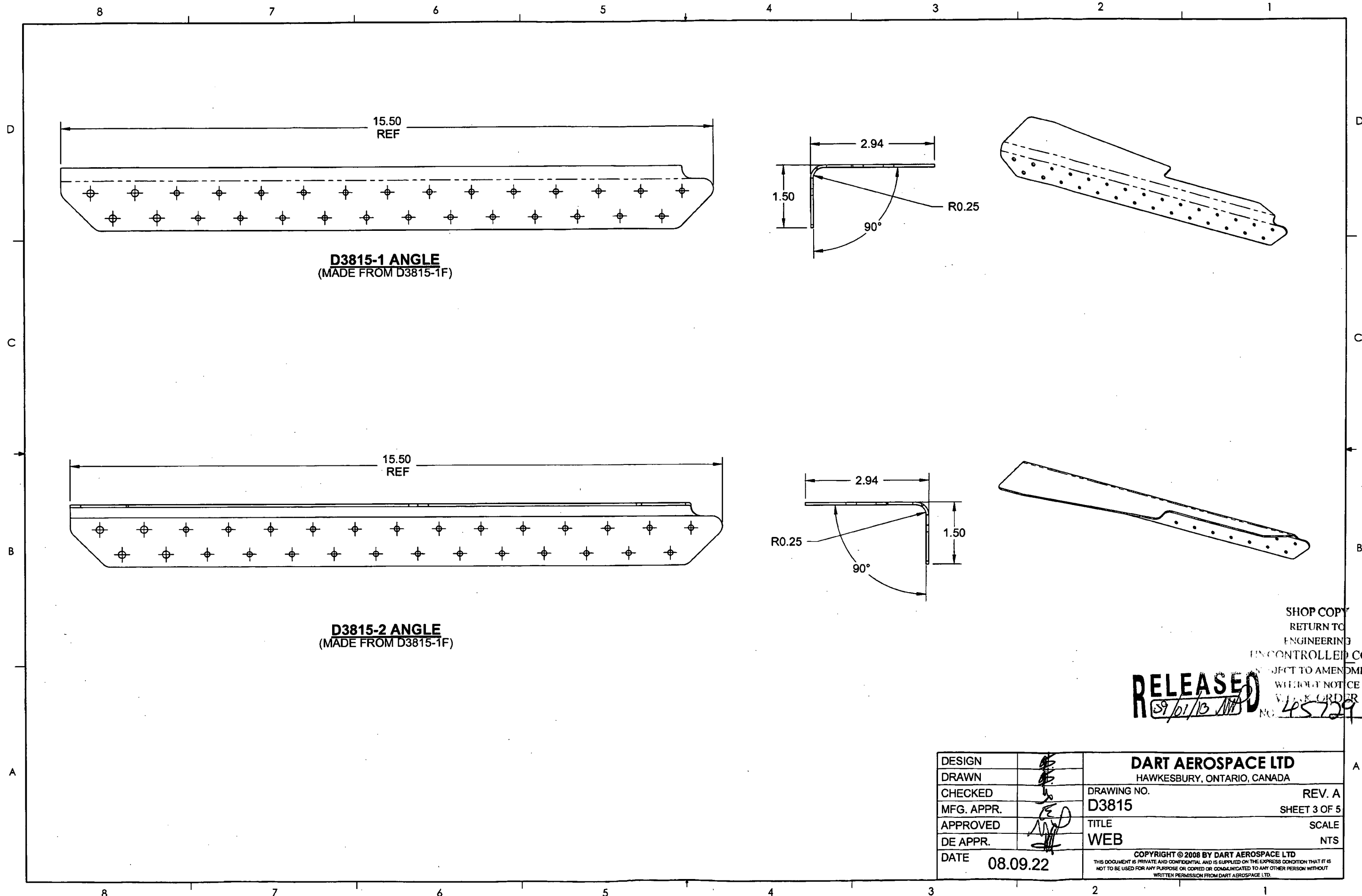
D3815-1F FLAT PATTERN

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- NOTES:**
- 1) MATERIAL: 2024-T3 X 0.063 ALUMINUM SHEET PER AMS-QQ-A-250/4 OR AMS 4037 (REF DART SPEC M2024T3S.063)
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES 0.005 TO 0.010
 - 4) IDENTIFICATION: N/A
 - 5) WEIGHT: 0.29 lbs

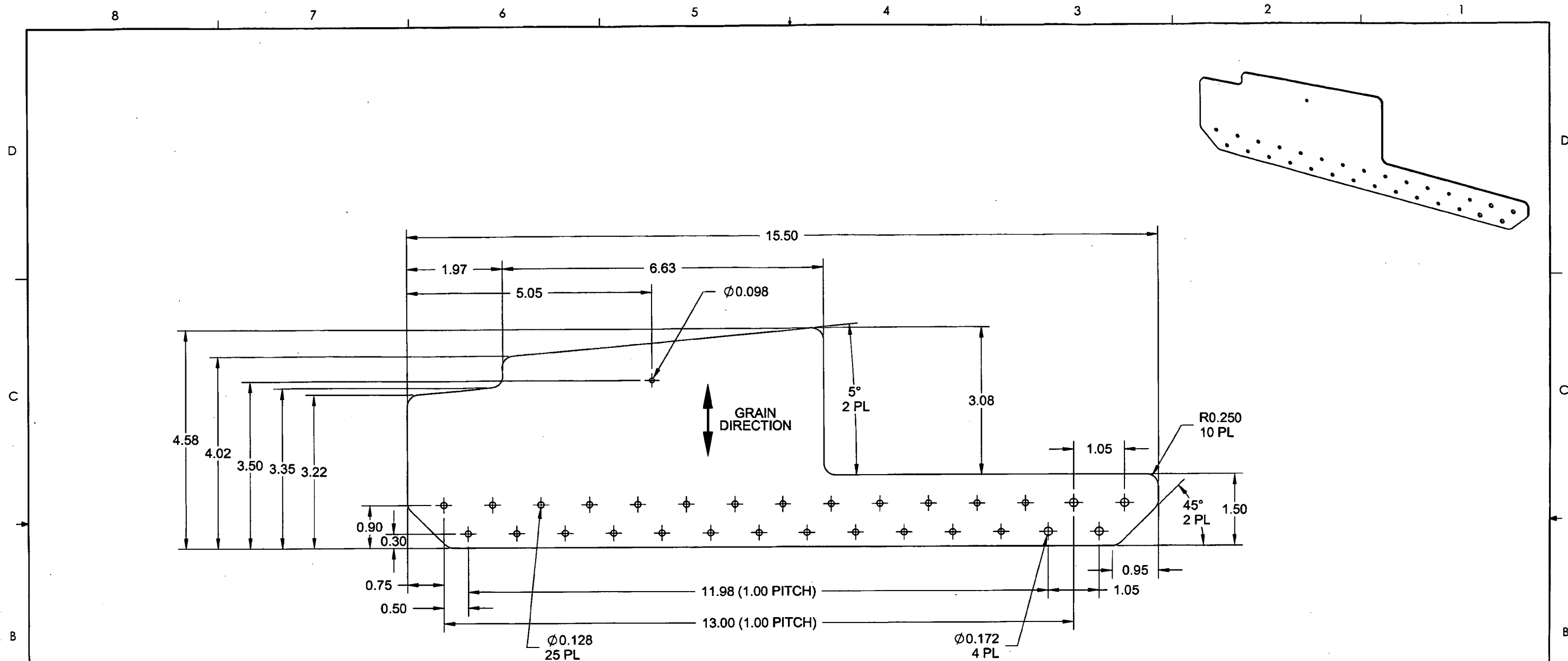
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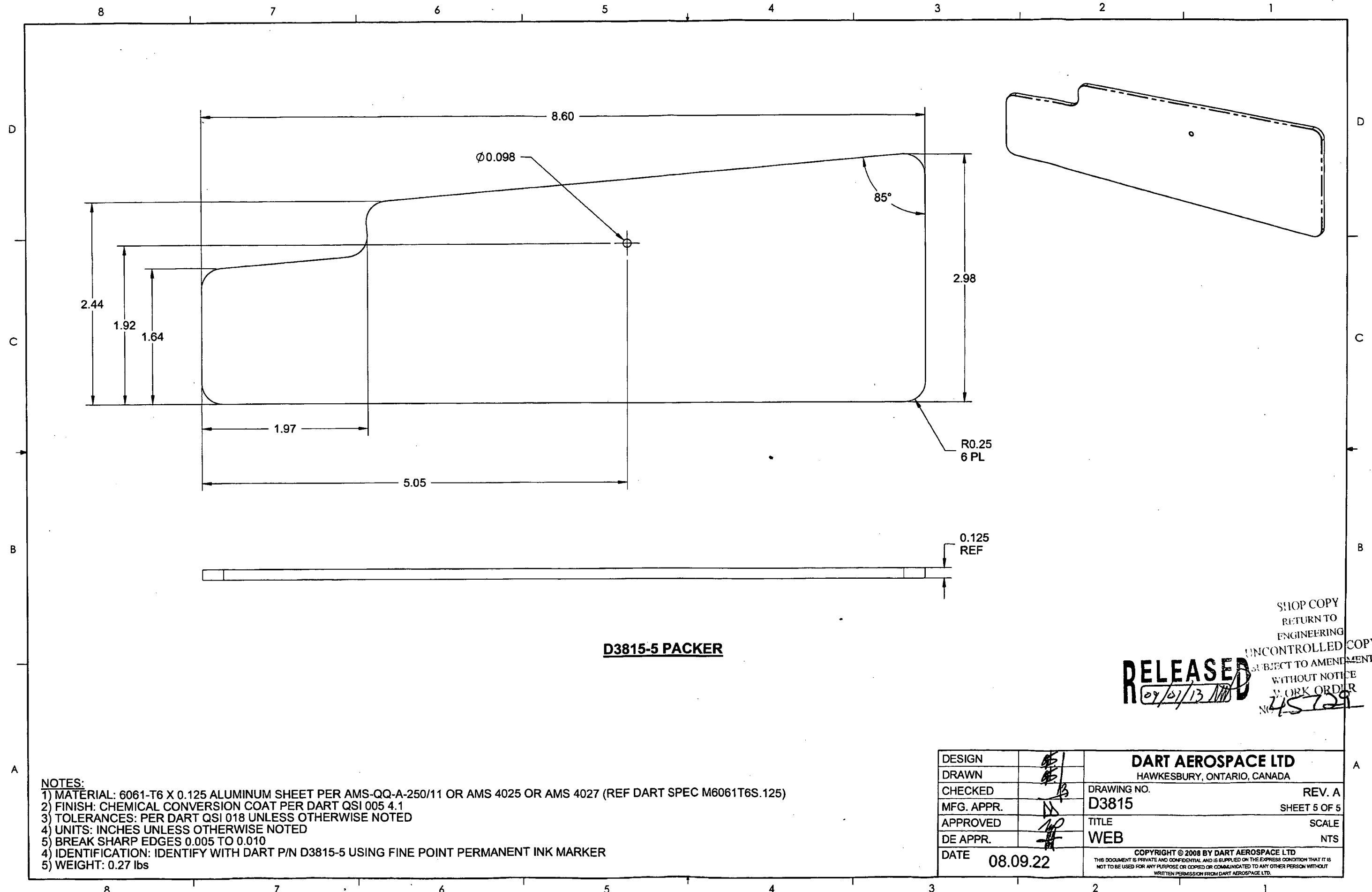
D3815-3 WEB

- NOTES:**
- 1) MATERIAL: 2024-T3 X 0.063 ALUMINUM SHEET PER AMS-QQ-A-250/4 OR AMS 4037 (REF DART SPEC M2024T3S.063)
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES 0.005 TO 0.010
 - 4) IDENTIFICATION: N/A
 - 5) WEIGHT: 0.28 lbs

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NOTES:

- 1) MATERIAL: 6061-T6 X 0.125 ALUMINUM SHEET PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF DART SPEC M6061T6S.125)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES 0.005 TO 0.010
- 4) IDENTIFICATION: IDENTIFY WITH DART P/N D3815-5 USING FINE POINT PERMANENT INK MARKER
- 5) WEIGHT: 0.27 lbs

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